

# Work Order ID 58210

Thursday, April 29, 2010 10:37:39 AM

Page 1

Item ID: D3065-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Step Spacer

Start Date: 4/29/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: mf Date: 10-4-29 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3065	Rev B

100 0.00



Waterjet

FLOW WATER JET

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3065 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 12-  
Deburr as required

2024 . 040

10-6-3

35

110 0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

Quality Control

0.00

10-6-3

120 0.00



QC

QC8- Inspect parts - second check

Memo

Quality Control

0.00

10/6/10

10/6/10  
35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Required Date: 5/14/2010 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary.

0.00

0.00

NA

140



Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg D3065

0.00

0.00

E/S 10/06/08  
SB 10/06/14

35

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/6/06/14

counted  
A35

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3065-1

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Setup Start



Revision ID:

Item Name: Step Spacer

Stop



Start Date: 4/29/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

35

10

06

15

35

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

35

10.06-15

180

Identify as per dwg & Stock Location WA

0.00



Packaging

Memo

0.00

Packaging

10.6-15

35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Item Name: Step Spacer

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Start Date: 4/29/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/15

1410-6-15  
35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, April 29, 2010 10:37:39 AM

Page 1

Work Order ID: 58210



Parent Item: D3065-1



Parent Item Name: Step Spacer

Start Date: 4/29/2010

Required Date: 5/14/2010

Comments: IPP: ☐C02.11.01 Incorporated D3066-1 IPP ☐KJ/RF ☐  
IPP: ☐D06.04.25 Water jet EC ☐

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

506.7000

0.1238

4.4



1810-6-3

2024-T3 .040 sheet

## Location

## Loc Qty

## Loc Code

MAT

96

114415

96

MAT22

410.7

110305

136.7

111786

18

112291

32

112331

64

113162

160

110305

35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	58210
<b>Description:</b> Step Spacer		<b>Part Number:</b>	D3065-1
<b>Inspection Dwg:</b> D3065 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	0.251	X			
2.093	+/-0.010	2.090	X			
3.936	+/-0.010	3.935	X			
4.186	+/-0.010	4.188	X			
0.587	+/-0.010	0.587	X			
Ø0.128	+0.005/-0.001	0.131	X			
R0.125	+/-0.010	0.125	X			
3.465	+/-0.010	3.464	X			
Ø1.250	+0.012/-0.001	1.252	X			
0.368	+/-0.010	0.364	X			
0.871 (Pitch)	+/-0.005	0.870	X			
0.040	+/-0.010	0.039	X			

<b>Measured by:</b>	12	<b>Audited by:</b>	S	<b>Prototype Approval:</b>	
<b>Date:</b>	10-6-3	<b>Date:</b>	10/06/03	<b>Date:</b>	10/6/03

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	07.02.07	Dimension 0.040 added	KJ/JLM	

# Dart Aerospace Ltd

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

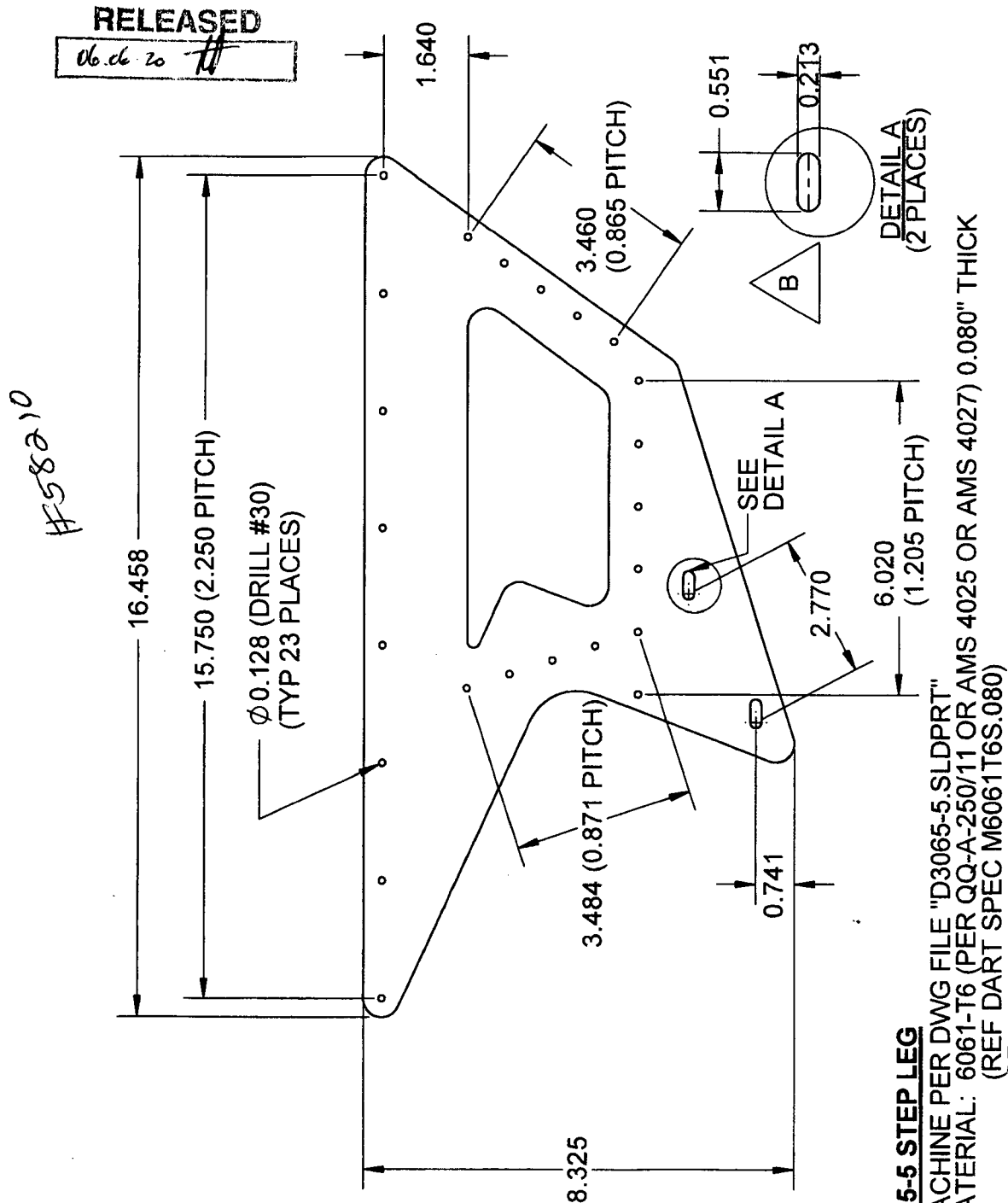
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>C.B.</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 4 OF 5
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>		SCALE 1:3



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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

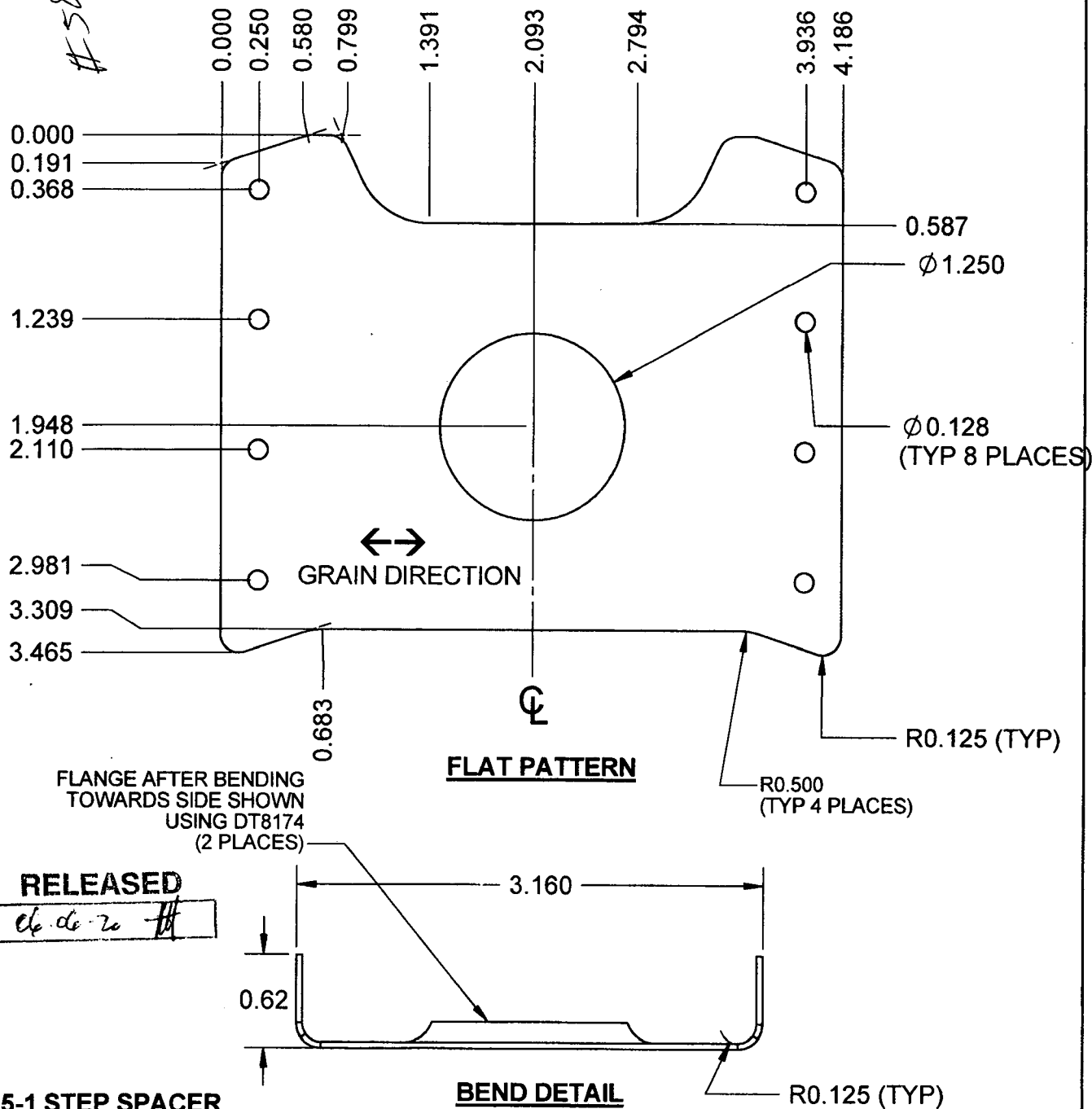
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 2 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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